

SEE DSI

* Custom *

Work Order ID 160107

160107

Page 1

Friday, April 21, 2017 9:50:47 AM

Item ID: D4017-041 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Short Basket Base Assembly (350)
 Start Date: 4/25/2017 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 5/1/2017 Req'd Qty: 1.00 *1* Customer:
 Reference: SCHEDULED/C CUSTOM
 Approvals: Process Plan: AA Date: APR 21 2017 Run Start *NR1*
 QC: Date: Tooling: Date: Stop *NR2*
 SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4017	E								
D4020	A								

100 Weld per dwg A/R S.S. rod Batch: 3136920 0.00

100

Large Fab

Large Fab

Memo

2.77

1- assemble ribs , weld as per dwg D4017 using DT9610B
 inspect before welding mesh

2- Cut mesh as per dwg D4020-3

3- tack weld mesh on basket as per dwg D4017 and trim mesh to fit if necessary
 and trim to clear fasteners holes on the ends

4- weld hinge (3) and Mounting brackets as per dwg D4017
 take lid to locate hinge and bracket

5- Weld D4672-3 blanking plates as per dwg

MAY 12 2017

DAS
24
9-891x CC 175-9

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.00

① 12-05-17DAS
9
9-89

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

160107

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Quality Control

DQA: _____ Date: _____



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Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER : _____							
Misidentified ☐	☐	Past Due								

Work Order ID 160107

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Item ID: D4017-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Short Basket Base Assembly (350)
Start Date: 4/25/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 5/1/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference: SCHEDULED/C CUSTOM

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Assemble as per dwg	0.00							
150									
HandFinish	Memo	0.63							
Hand Finishing									
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.02							
Quality Control									
170	Identify as per dwg & Stock Location: <u>w/o</u>	0.00							
170									
Packaging	Memo	0.01							
Packaging									

Handwritten notes: 1 & d 17/05/17 1 & d 17/05/17 0-1032-041 / 13160105 1 & d 17/05/17

Stamp: DAS 38 9-89 MAY 17 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval					

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
				Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
				OTHER : ☐			

Work Order ID 160107

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Item ID: D4017-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Short Basket Base Assembly (350)
Start Date: 4/25/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 5/1/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference: SCHEDULED/C CUSTOM

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.10							
Quality Control									

17/5/18 *[Signature]*
DAS
21
9-89 MAY 18 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : _____									

Picklist Print

Friday, April 21, 2017 9:50:46 AM

Page 1

Work Order ID: 160107

160107

Parent Item: D4017-041

D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 4/25/2017

Required Date: 5/1/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as
per dwg RevA DD 10.03.06 verified by:EC IPP Rev:C as per dwg
RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD
10.08.18 verified by:EC IPP Rev:E 10.11.04 added pressure wash
DD verf:EC IPP REV:F 12.07.24 AS PER DWG REV.D DD
VERF:EC IPP REV:G 13.08.21 DWG REV.E / ECN 13-624 DD
VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4672-3

Manufactured

No

100

Each

34.0000

2

2

D4672-3

Blanking Plate

**

Location

Loc Qty

Loc Code

WA004

34

141230

4

157868

30

M304EX0.75-16F

Purchased

No

100

sf

450.5000

19.1516

19.1516

M304FX0 75-16F

Expanded Metal Flat SS

**

Location

Loc Qty

Loc Code

WA004

450.5

M136991

30.5

M137294

420

D4017-1

Manufactured

No

100

Each

12.0000

1

1

D4017-1

Rib

**

Location

Loc Qty

Loc Code

WA004

12

144884

1

148052

11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____			

Picklist Print

Friday, April 21, 2017 9:50:46 AM

Work Order ID: 160107

160107

Parent Item: D4017-041

D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 4/25/2017

Required Date: 5/1/2017

Start Qty: 1.00

Required Qty: 1.00

✓ D4017-3
D4017-3
Rib

Manufactured No 100 Each 4.0000 1 1

**

CC 17-5-4

Location Loc Qty Loc Code

WA004

4

148053

4

(1x)

✓ D4017-5
D4017-5
Hinge Rib

Manufactured No 100 Each 10.0000 1 1

**

CC 17-5-4

Location Loc Qty Loc Code

WA004

10

155747

2

157843

8

(1x)

✓ D4017-7
D4017-7
Rib

Manufactured No 100 Each 10.0000 3 3

**

CC 17-5-4

Location Loc Qty Loc Code

WA004

10

158860

10

(3x)

✓ D4017-9
D4017-9
Rib

Manufactured No 100 Each 8.0000 2 2

**

CC 17-5-4

Location Loc Qty Loc Code

WA004

8

155938

2

157621

6

(2x)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
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Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
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Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 160107

160107

Parent Item: D4017-041

D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 4/25/2017

Required Date: 5/1/2017

Start Qty: 1.00

Required Qty: 1.00

✓ D3916-041	Manufactured	No	100	Each	8.0000	2	2	
D3916-041								
Rib Assembly								
						**		CC 17-5-4

					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
✓ D3916-5	Manufactured	No	100	Each	6.0000	1	1	
D3916-5								
Light Rib								
					WA004	8		
					157746	8		(2x)
								CC 17-5-4
								**

					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
✓ D4034-041	Manufactured	No	100	Each	5.0000	1	1	
D4034-041								
Aft Upper Rib Assembly								
					WA004	6	B157561	(1x)
					157731	6		CC 17-5-4
								**

					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
✓ D4034-043	Manufactured	No	100	Each	5.0000	1	1	
D4034-043								
Fwd Upper Rib Assembly								
					WA004	5	B160516	(1x)
					152920	1		CC 17-5-4
					157479	4		**

					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
					WA004	5		
					153910	1		(1x)
					157739	4		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coor. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By _____					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Page 4

Work Order ID: 160107

160107

Parent Item: D4017-041

D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 4/25/2017

Required Date: 5/1/2017

Start Qty: 1.00

Required Qty: 1.00

D2581

Manufactured No

100

Each

88.0000

2

2

D2581

Mounting Bracket

**

CC 17-5-4

Location

Loc Qty

Loc Code

WA004

88

152803

38

157620

26

159116

24

D3913-15

Manufactured No

100

Each

19.0000

1

1

D3913-15

Wide Handle Plate

**

CC 17-5-4

Location

Loc Qty

Loc Code

WA004

19

157671

19

D4016-1

Manufactured No

100

Each

69.0000

3

3

D4016-1

Hinge Half, Base

**

CC 17-5-4

Location

Loc Qty

Loc Code

WA004

69

154145

17

155346

12

158630

40

D4020-11

Manufactured No

100

Each

21.0000

2

2

D4020-11

End Mesh, Basket

**

CC 17-5-6

Location

Loc Qty

Loc Code

WA004

21

152541

1

154521

2

156918

10

157499

8

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Page 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Friday, April 21, 2017 9:50:46 AM

Work Order ID: 160107

160107

Parent Item: D4017-041

D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 4/25/2017

Required Date: 5/1/2017

Start Qty: 1.00

Required Qty: 1.00

D2931 Manufactured No 150 Each 1,370.000 2 2

D2931

Bumper

MAY 16 2017

DAS
6
9-80

Location	Loc Qty	Loc Code
ST013	70	
86435	70	
ST025A	1300	
86435	1300	

2

D4021-1 Manufactured No 100 Each 45.0000 3 3

D4021-1

Handle Plate

CC 17-5-4

Location	Loc Qty	Loc Code
WA004	45	
157523	30	
159375	15	

3x

D4021-5 Manufactured No 150 Each 19.0000 2 2

D4021-5

Blanking Plate

MAY 16 2017

DAS
6
9-80

Location	Loc Qty	Loc Code
ST071	19	
155240	2	
156433	6	
157458	11	

2

AN3-10A Purchased No 150 Each 236.0000 6 6

AN3-10A

Bolt

MAY 16 2017

DAS
6
9-80

Location	Loc Qty	Loc Code
GA	60	
m136787	60	
ST349	176	
m137321	176	

6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date ☐	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified ☐	☐	Past Due	☐				

Picklist Print

Friday, April 21, 2017 9:50:46 AM

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Work Order ID: 160107

160107

Parent Item: D4017-041

D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 4/25/2017

Required Date: 5/1/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149DN832J Purchased No 150 Each 750.0000 2 2
NAS1149DN832J
 Washer

MAY 16 2017

DAS
6
9-89

MS20600-AD4W3 Purchased No 150 Each 218.0000 2 2
MS20600-AD4W3
 Cherry Rivet

MAY 16 2017

DAS
6
9-89

MS21042L3 Purchased No 150 Each 2,126.0000 6 6
MS21042L3
 Nut

MAY 16 2017

DAS
6
9-89

Location	Loc Qty	Loc Code
ST264	750	
M135297	750	
ST308	158	
m135603	158	
WA003	60	
m136648	60	
FP001	100	
m135945	100	
GA	168	
m134360	102	
M136665	66	
OVER007	1300	
m134360	0	
M136665	300	
m137321	1000	
ST303	558	
m137073	58	
m137166	500	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Page 7

Friday, April 21, 2017 9:50:46 AM

Work Order ID: 160107

160107

Parent Item: D4017-041

D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 4/25/2017

Required Date: 5/1/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149F0332P

Purchased

No

150

Each

1,410.000

12

12

NAS1149F0332P

**

Washer

DAS
6
9-89
MAY 1 6 2017

Location

Loc Qty

Loc Code

GA

275

m133709

275

ST262

1135

m136835

8

m137075

1127

12

~~5519-041~~ → ~~B159991~~ →

~~5519-043~~ → ~~B159993~~ →

ASI 9776-011

Qty 1

~~160996~~ B160996

DAS
24
9-89

MAY 1 2 2017

ASI 9776-015

Qty 1

~~160994~~ B160994

DAS
24
9-89

MAY 1 2 2017

~~Bushing D4021-9~~ → ~~B158785~~ → ~~(1) 17-5-8~~

Friday, April 21, 2017 9:50:46 AM

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Page 7

DQA: _____ Date: _____



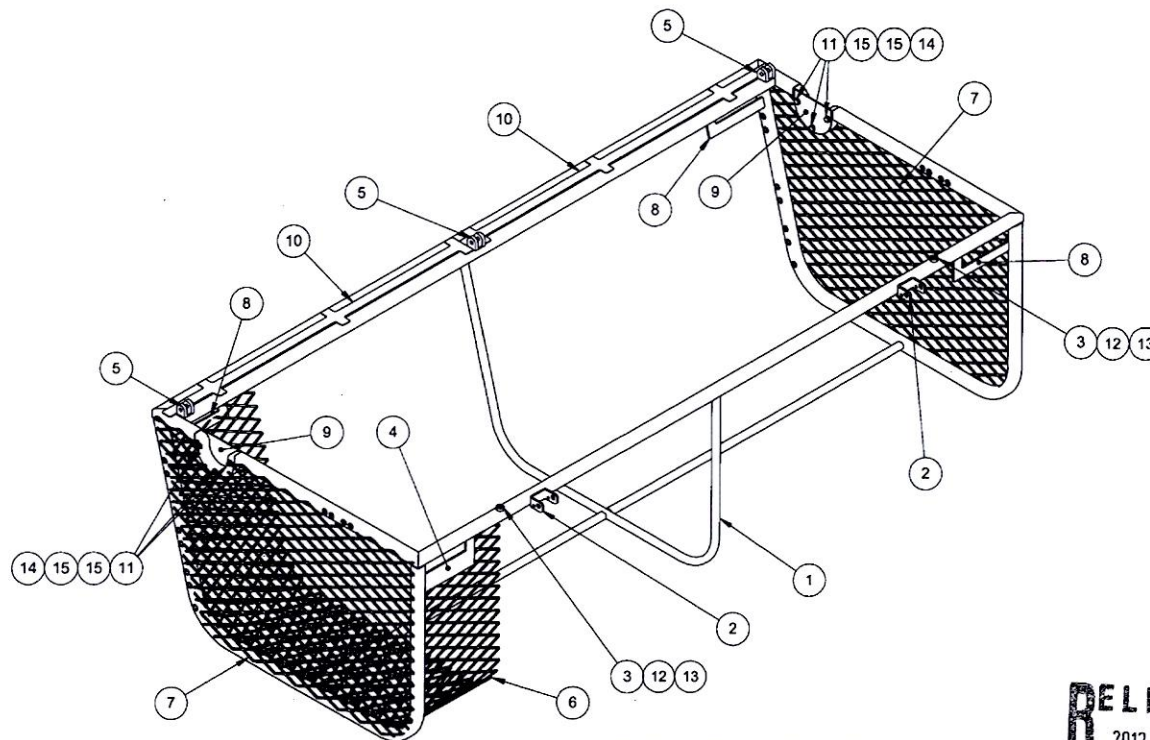
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4017-041	SHORT BASKET ASSY (350)
1	1	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
2	2	D2581	MOUNTING BRACKET
3	2	D2931	BUMPER
4	1	D3913-15	WIDE HANDLE PLATE
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-3	MESH (350 BASKET SHORT BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	2	D4672-3	BLANKING PLATE
11	6	AN3-10A	BOLT, MACHINE
12	2	AN960JD8	WASHER
13	2	MS20600AD4W3	RIVET, BLIND, PAN-HEAD
14	6	MS21042L3	NUT, SELF-LOCKING
15	12	NAS1149F0332P	WASHER



D4017-041 SHORT BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2013-08-16

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 160107112

APR 21 2017

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 28.8 lbs APPROX
 - 8) INSTALL AFTER FINISH
 - 9) MASK HOLES PRIOR TO POWDER COAT
 - 10) WELD PER DART QSI 004

E	PICTORIAL UPDATE TO MULTIPLE VIEWS FOR CHANGES TO D4034-043. A4-4 28.13 DIM IS NOW REF.	AJS	13.07.18
D	ADD D4672-3 (ZN C5-1, D4-1, D6-1, D3-2, AND D4-2). REASON: PAR12-197.	MB	12.06.18
C	ITEM #4 NOW INSTALLED OUTBOARD (C4-1, C5-1, B5-2 AND D8-2). REASON: ELIMINATE INTERFERENCE PREVENTING INSTALLATION OF RECEIVER ASSEMBLIES.	MB	10.07.23
B	QTY 1 D4021-1 REPLACED WITH QTY 1 D3913-15; AN3-10A BOLT WAS AN3C10A; NAS1149F0332P WASHER WAS NAS1149C0332R; SECTION F-F UPDATED (D8-2); ITEMS RENUMBERED; DETAIL D UPDATED (A4-3)	JPH	10.03.25
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE

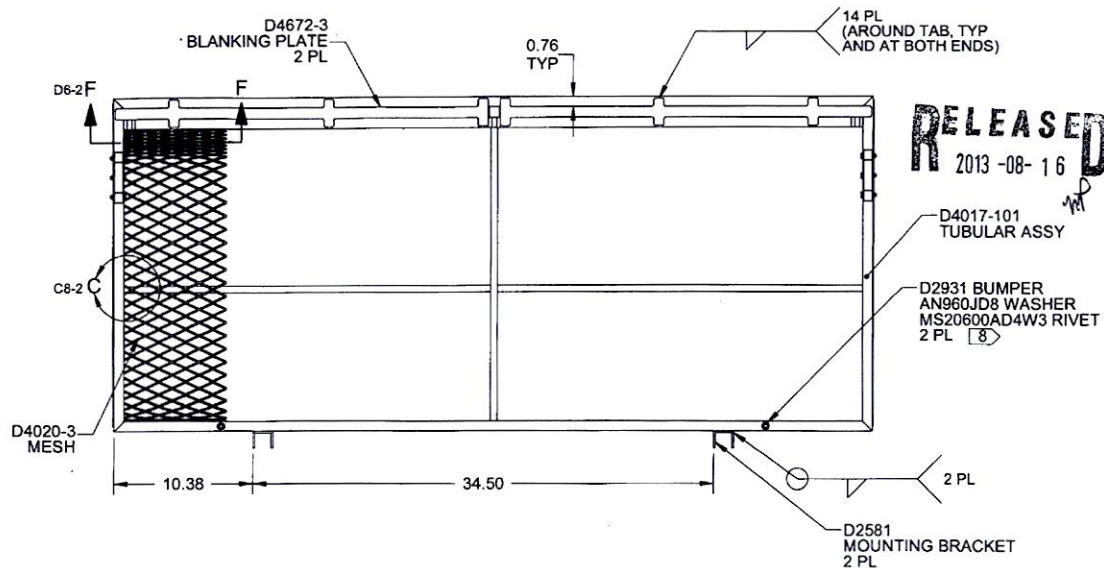
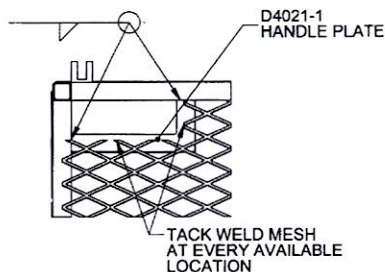
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D4017	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET BASE ASSY (350)	NTS
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

TACK WELD MESH
AT EVERY AVAILABLE
LOCATION

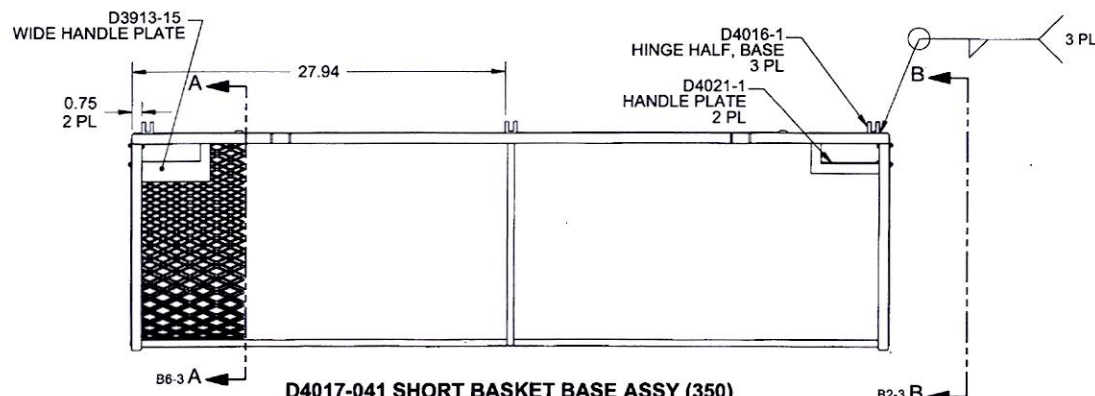
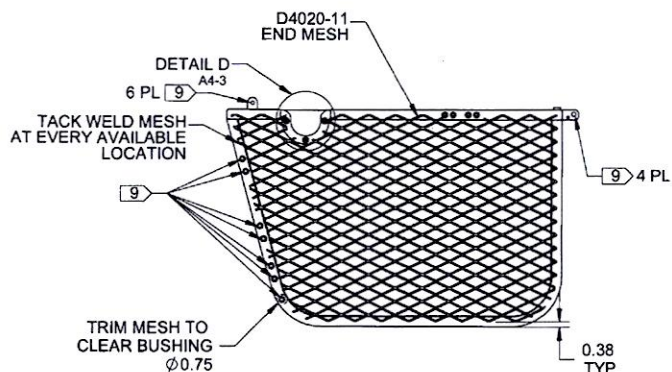


DETAIL C D5-2

SECTION F-F
TYPICAL FOR ALL
HANDLE PLATES



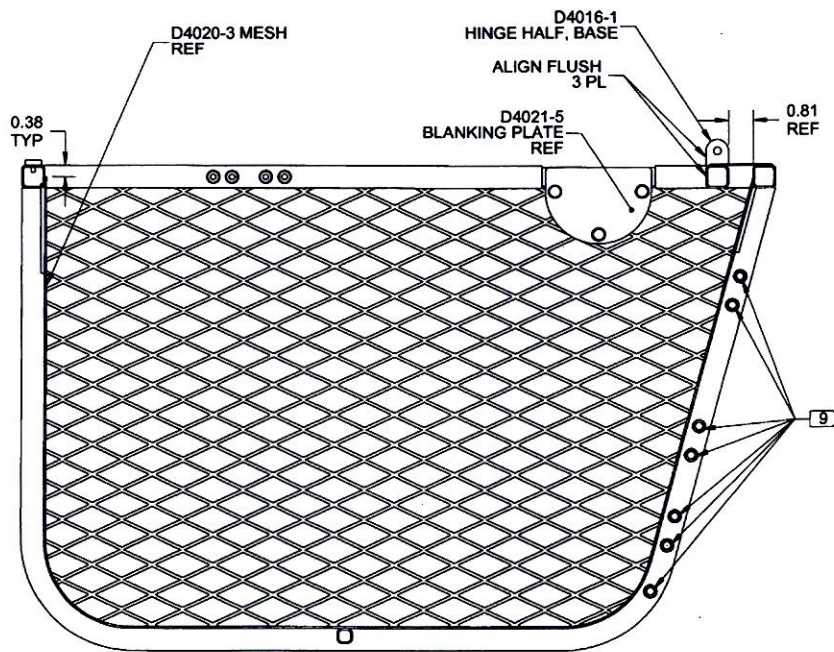
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2013-08-16



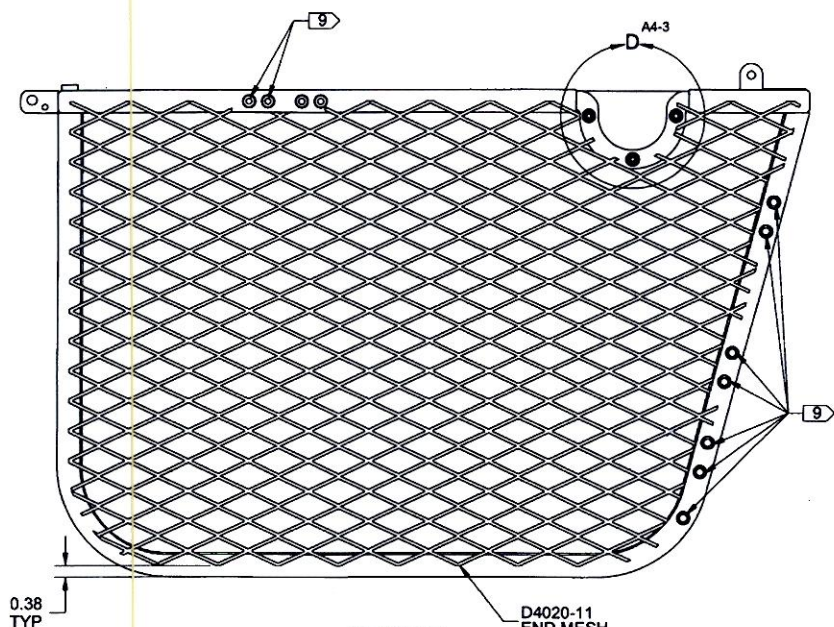
D4017-041 SHORT BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D4017	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET BASE ASSY (350)	NTS
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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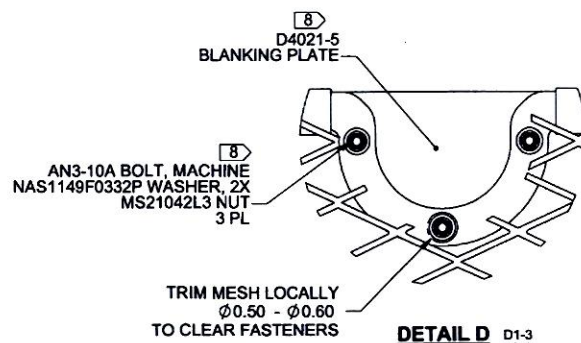
8 7 6 5 4 3 2 1



SECTION A-A A5-2



VIEW B-B A2-2



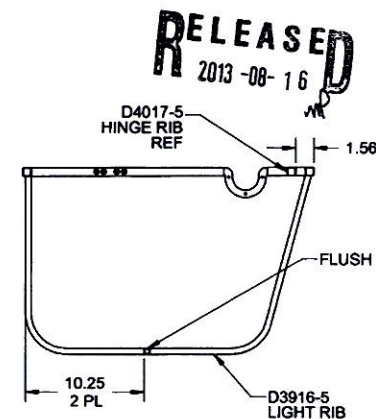
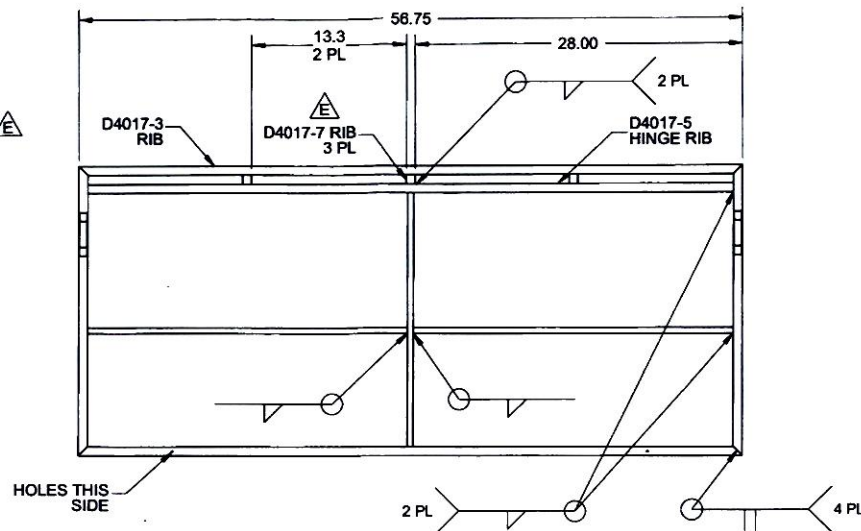
DETAIL D D1-3 B7-2

RELEASED
2013-08-16

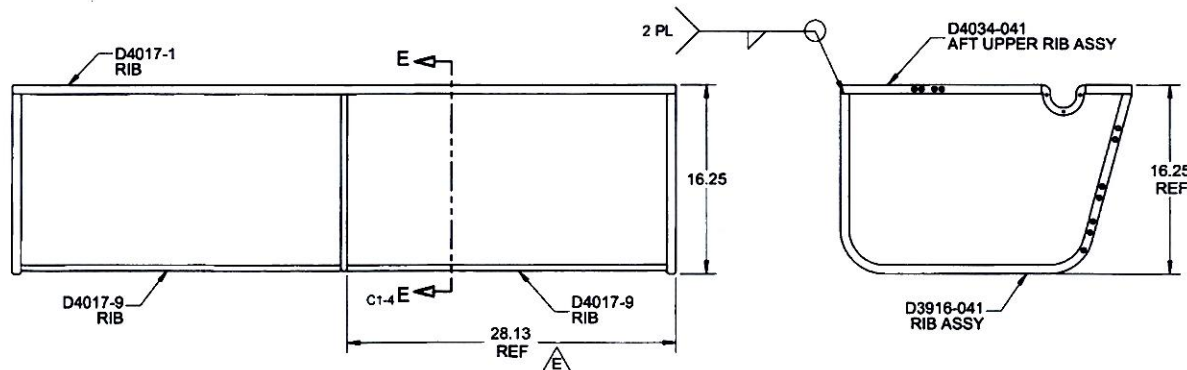
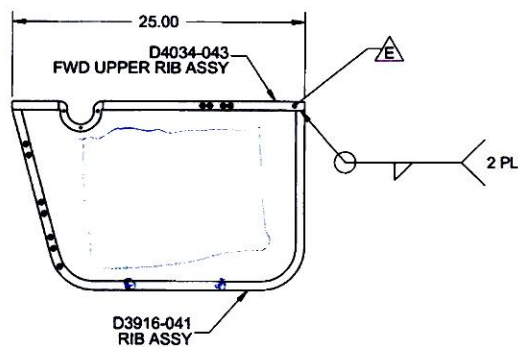
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4017	REV. E
MFG. APPR.		TITLE	SHEET 3 OF 5
APPROVED		SHORT BASKET BASE ASSY (350)	SCALE
DE APPR.			NTS
DATE	13.07.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

ITEM	QTY -101	P/N	DESCRIPTION
	X	D4017-101	TUBULAR ASSY (350 SHORT BASKET)
1	1	D4017-1	RIB
2	1	D4017-3	RIB
3	1	D4017-5	HINGE RIB
4	3	D4017-7	RIB
5	2	D4017-9	RIB
6	1	D3916-5	LIGHT RIB
7	2	D3916-041	RIB ASSY
8	1	D4034-041	AFT UPPER RIB ASSY
9	1	D4034-043	FWD UPPER RIB ASSY



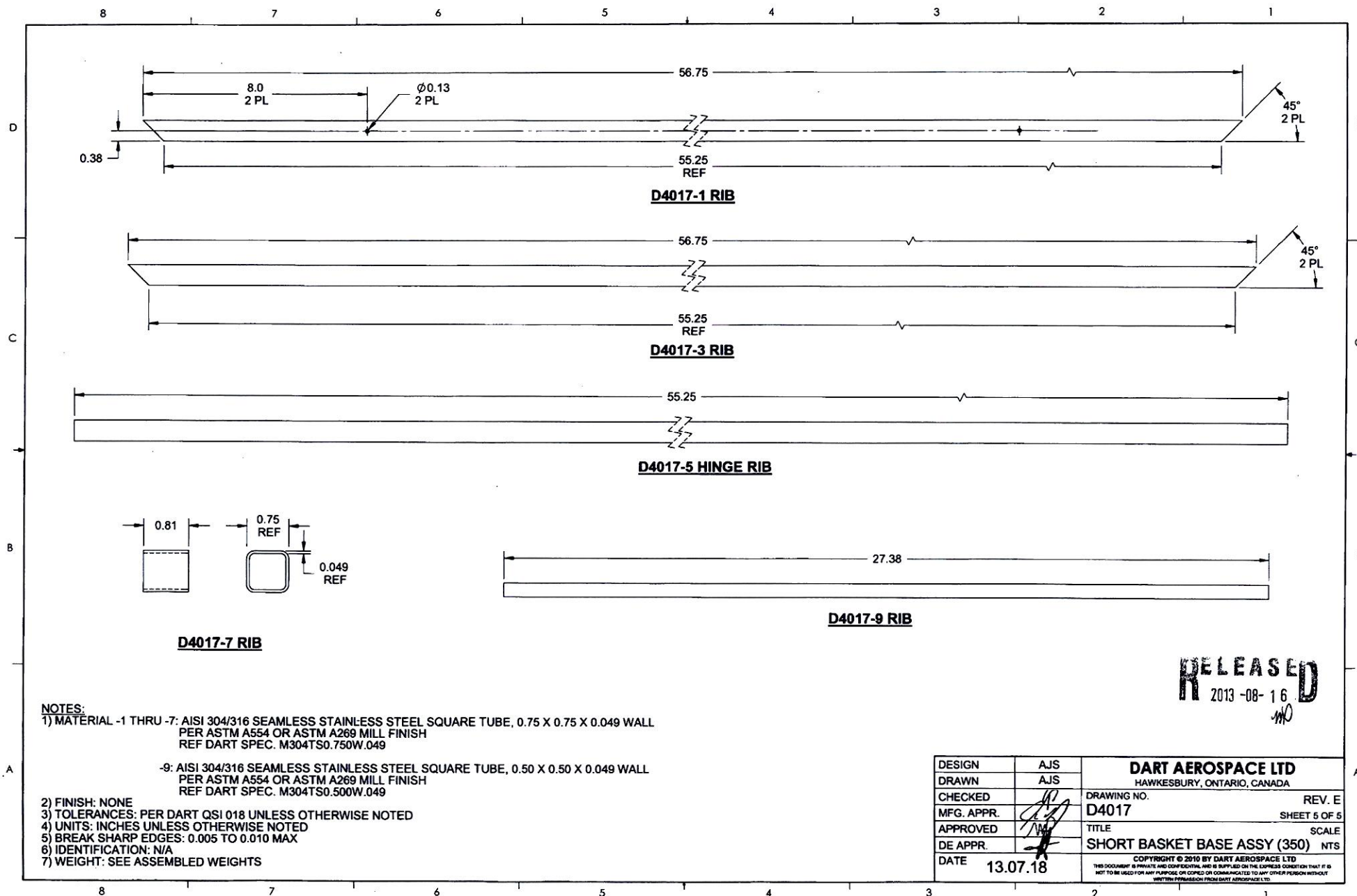
SECTION E-E A4-4

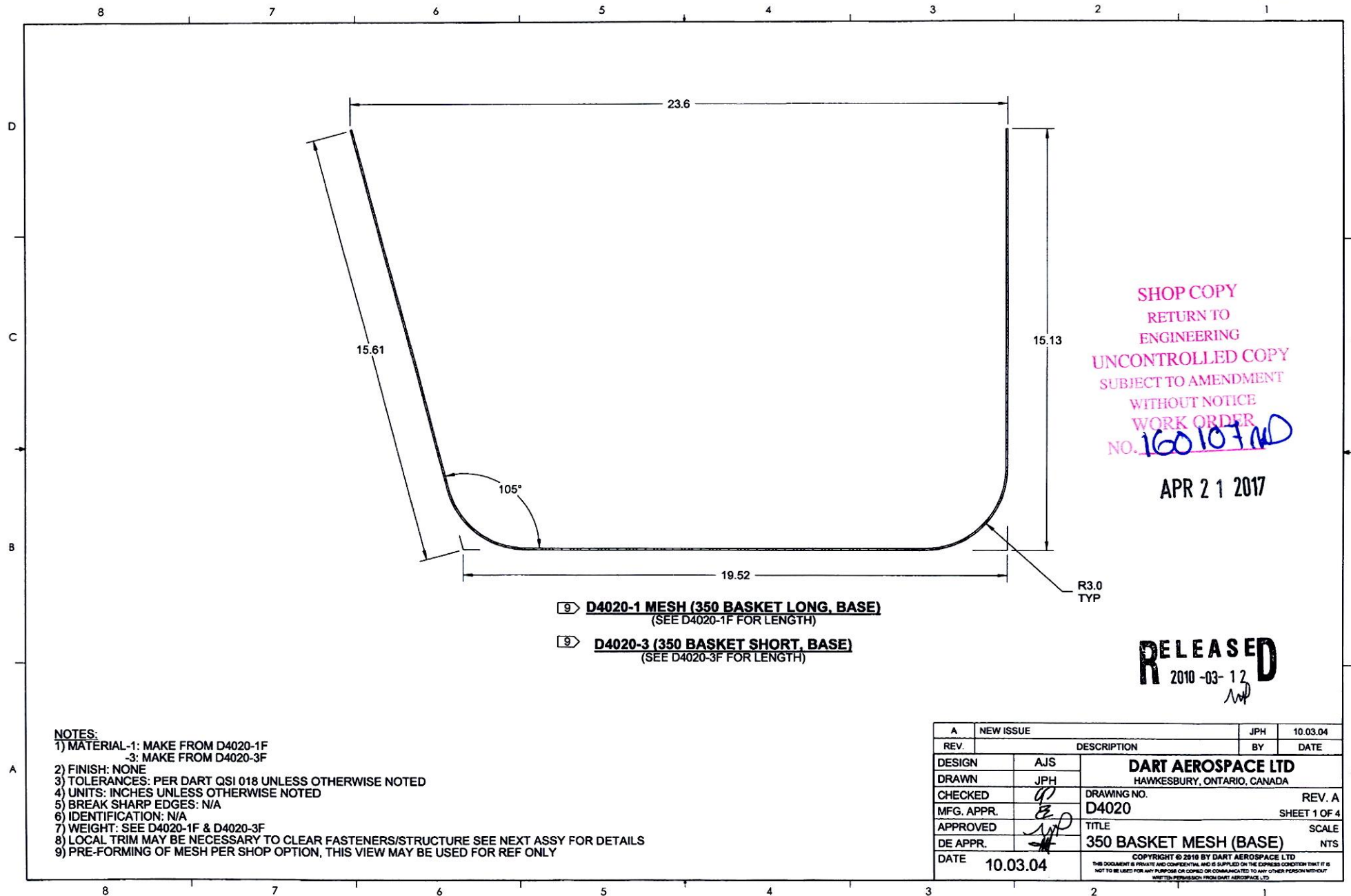


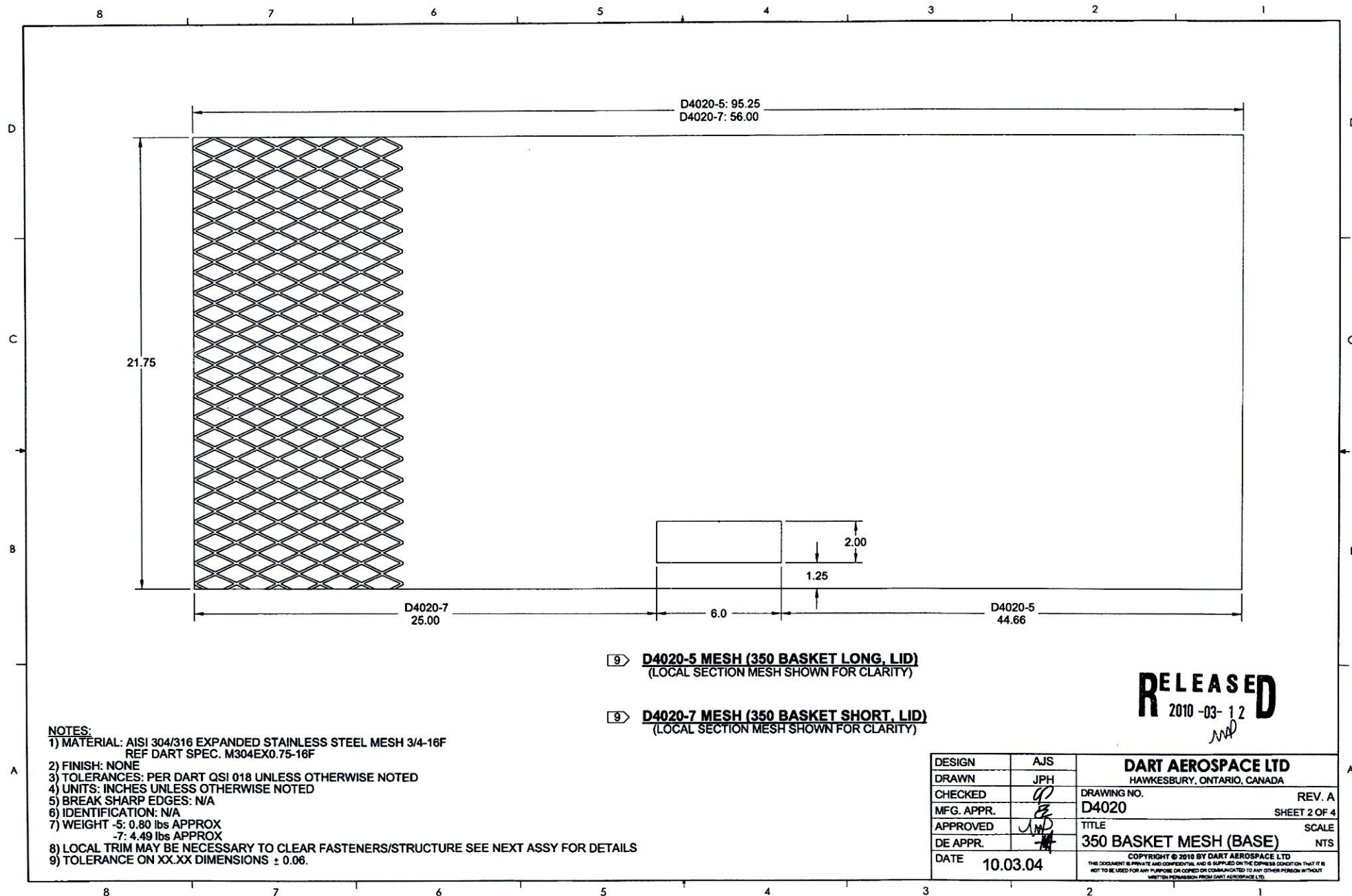
8 D4017-101 TUBULAR ASSY (350 SHORT BASKET)

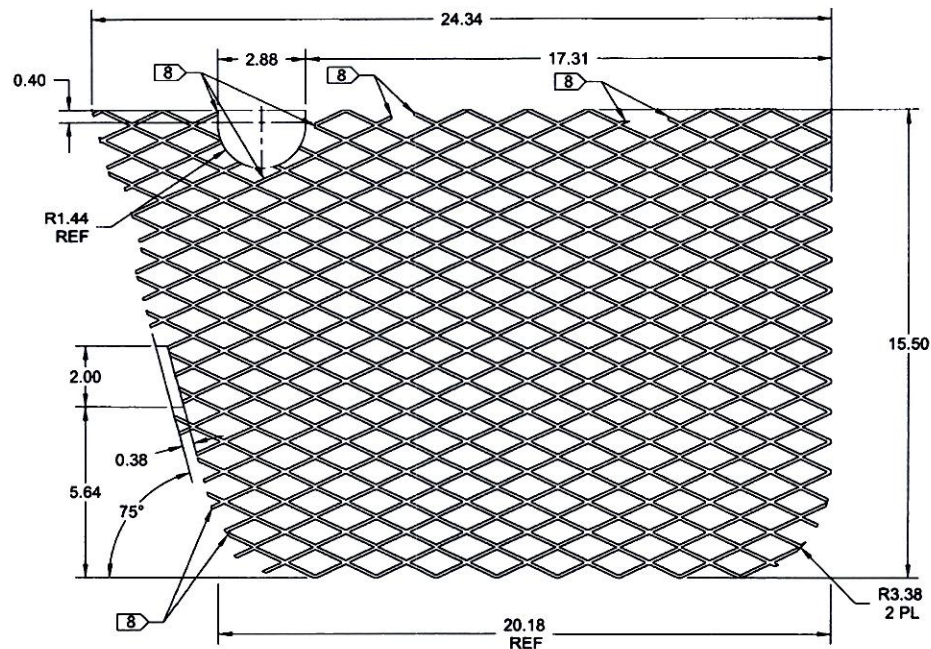
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 15.38 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4017-101
 - 9) WELD PER DART QSI 004

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DE APPR.	<i>[Signature]</i>	SHORT BASKET BASE ASSY (350)	NTS
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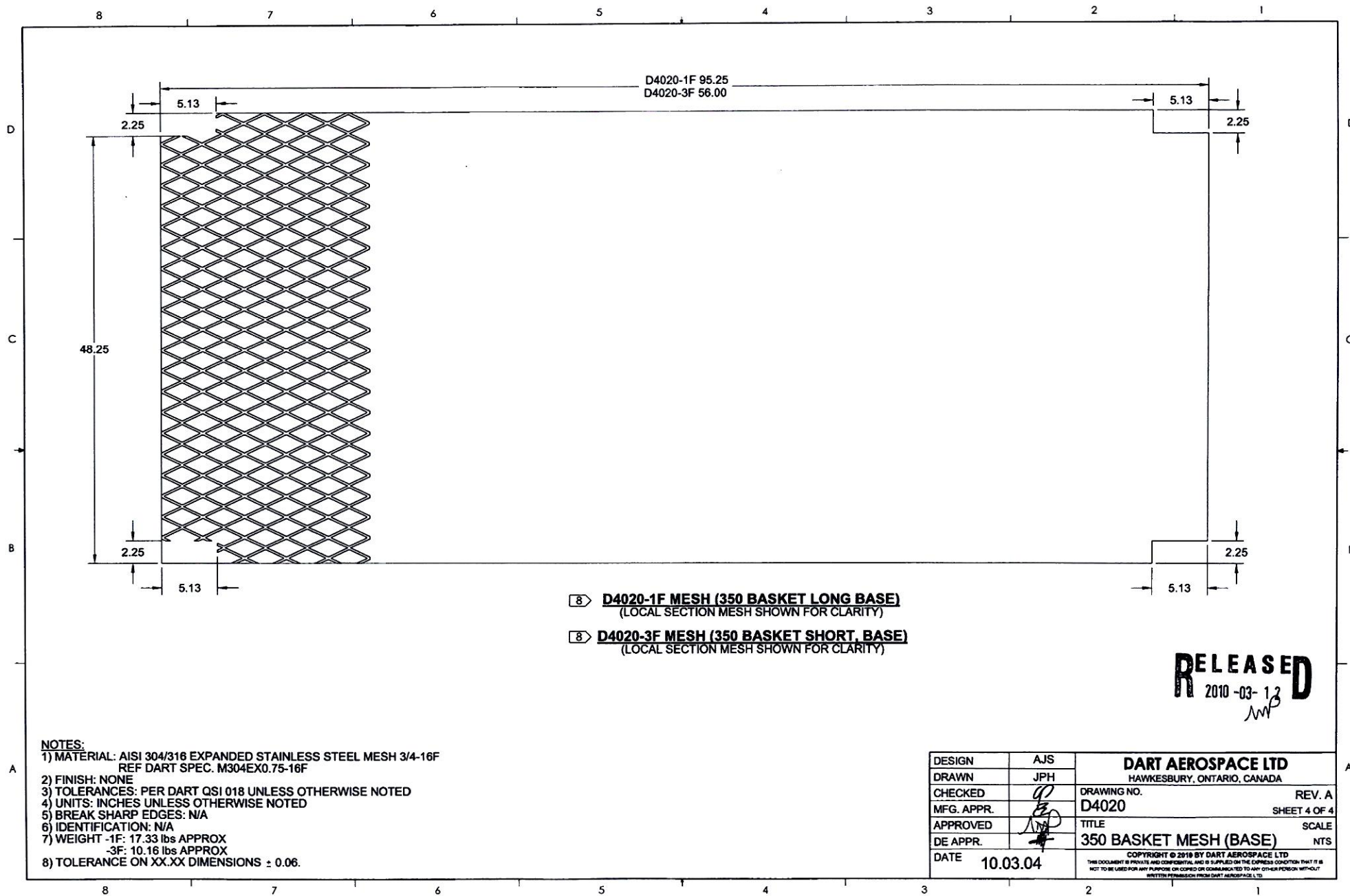
9 D4020-11 END MESH, BASKET

NOTES:

- 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F
REF DART SPEC. M304EX0.75-16F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.22 lbs
- 8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
- 9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06 .

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MFG. APPR.	JP	TITLE 350 BASKET MESH (BASE)	SCALE NTS
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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-607-3 REV. D

REF TCCA STC: SH94-14
REF FAA STC: SR00213NY
REF EASA STC: 10016996

1.0 PURPOSE

This Dart Service Instruction provides parts and instructions for modifying the D350-607-541/-543/-545/-547 Heli-Utility-Basket Assemblies for specialty mission equipment.

The DSI 9776-011/-013/-15 kits consist of the parts required to modify the basket base assembly of D350-607-541/-543/-545/-547 Heli-Utility-Basket Assemblies.

Note: All dimensions shown in parentheses [] are in millimeters, otherwise in inches.

It is not mandatory for all of the covers shown in this DSI Installation be installed.

Although not normally required, it is permissible for operators to use longer or shorter bolts and thinner or thicker washers to ensure that all fasteners are in safety (minimum of 1.5 threads exposed). **Bolts that do not have the minimum of 1.5 threads exposed after installation of the nut must be replaced with longer bolts by the customer.**

Min distance from edge of Basket to center of D5519-043 Doubler Assy = 5.5" [140 mm].

Min distance between D5519-043 Doubler Assy (measured center to center) = 7.0" [178 mm].

D5519-043 Doubler Assy cannot be placed over the basket ribs.

D5519-043 Doubler must be installed on the flat portion of the expanded metal (Bottom or sides of basket).

All welding must be per MIL-STD-2219/AMS-STD-2219 Class 'C' using ER308L or ER316L filler rod.

2.0 INSTALLATION OF DSI 9776-011 END COVER KIT (Short Basket Assembly):

Note: This section provides instructions to install a D5519-041 Doubler Assy with a D5519-3 Cover Plate in both ends of the basket. It is also acceptable to install these parts at one end of the basket only.

- 2.1 At the customer's discretion, disassemble D4032-041 Short Basket Assembly by removing D4018-041/D4019-041 Short Basket Lid Assembly and retain hardware to facilitate this modification.
- 2.2 Locate the D3916-041 Rib Assembly at each end of the D4017-041 Short Basket Base Assy as shown in Figure 3. Partially remove the expanded metal as shown in Figure 3 Sections C-C & D-D.
- 2.3 Mark and drill 2x 0.375" holes at each end of the D3916-041 Rib Assemblies as shown in Figure 2 per Section A-A & B-B. Countersink 0.375" holes in the rib to 0.435 x 45 on both sides of the ribs. Deburr holes.
- 2.4 Drill 4x 0.098" (#40 drill) for MS21059L3 anchor nuts thru only the wall of each of the D3916-041 Rib Assembly on the D4017-041 Short Basket Base Assy as shown in Figure 2. Deburr holes.
- 2.5 Weld 4x D4021-9 Bushings into 0.375" holes and grind flush on both sides of the D4016-041 Rib Assemblies per Figure 2.
- 2.6 Install MS21059L3 anchor nuts per Figure 3.
- 2.7 Temporarily position the D5519-041 Doubler Assy by aligning the two bottom holes with the two bottom bushing holes on each of the D3916-041 Rib Assy. Locally trim (0.13" - 0.25") the expanded metal that overlaps with any of the MS21059L3 anchor nuts as shown in Figure 3 Section C-C and D-D.
- 2.8 Tig weld (tack weld) expanded metal at every available location attaching the D5519-041 Doubler Assy to the D3916-041 Rib Assemblies. Also tack weld the two packers into the bottom with the D3916-041 Rib Assemblies.
- 2.9 If incorporating this DSI during basket production, powder coat entire basket base per D4017 drawing. Mask MS21059L3 anchor nut holes prior to powder coat.
- 2.10 If incorporating this DSI post basket production, paint repaired areas per ICA-D350-607.

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- 2.11 Install a D5519-3 Cover plate onto each end of the D4017-041 Basket Base Assy using hardware as shown in Figure 1.
- 2.12 If applicable, re-assemble the modified D4032-041 Short Basket Assembly by attaching the modified D4017-041 Short Basket Base Assy to D4018-041/D4019-041 Short Basket Lid Assembly with the retained hardware.
- 2.13 Re-install basket per ICA-D350-607. Replace any worn hardware as necessary per Chapter 5 of ICA-D350-607.
- 2.14 Update the aircraft log book to indicate installation of the DSI 9776-011 End Cover Kit. Update the aircraft Weight and Balance per Section 7.0.

3.0 INSTALLATION OF DSI 9776-013 END COVER KIT (Long Basket Assembly):

Note: This section provides instructions to install a D5519-041 Doubler Assy with D5519-3 Cover Plate in both ends of the basket. It is also acceptable to install these parts at one end of the basket only.

- 3.1 At the customer's discretion, disassemble D4030-041 Long Basket Assembly by removing D3914-041/D3915-041 Long Basket Lid Assembly and retain hardware to facilitate this modification.
- 3.2 Locate the D3916-5 Rib at each end of the D3913-041 Long Basket Base Assy as shown in Figure 8. Partially remove the expanded metal as shown in Figure 8 Sections G-G & H-H.
- 3.3 Mark and drill 2x 0.297" holes at each end of the D3916-5 ribs as shown in Figure 7 Section E-E & F-F. Countersink 0.297" holes in the ribs to 0.357 x 45 in both sides of the ribs. Deburr holes.
- 3.4 Drill 4x 0.098" (#40 drill) for MS21059L3 anchor nuts thru only the wall of each of the D3916-5 Ribs on the D3913-041 Long Basket Base Assy as shown in Figure 7. Deburr holes.
- 3.5 Weld 4x D5338-1 Bushings into the 0.297" holes and grind flush on both sides of the D3916-5 Ribs.
- 3.6 Install MS21059L3 anchor nuts per Figure 8.
- 3.7 Temporarily position the D5519-041 Doubler Assemblies by aligning the two bottom holes with the two bottom bushing holes on each of the D3916-5 Ribs. Locally trim (0.13" - 0.25") the expanded metal that overlaps with any of the MS21059L3 anchor nuts as shown in Figure 8 Section G-G and H-H.
- 3.8 Tig weld (tack weld) expanded metal at every available location attaching the D5519-041 Doubler Assy on the D3916-5 Ribs. Also tack weld the two packers into the bottom with the D3916-5 Ribs.
- 3.9 If incorporating this DSI during basket production, powder coat entire basket base per D3913 drawing. Mask MS21059L3 anchor nut holes prior to powder coat.
- 3.10 If incorporating this DSI post basket production, paint repaired areas per ICA-D350-607.
- 3.11 Install a D5519-3 Cover plate onto each end of the D3913-041 Long Basket Base Assy using hardware as shown in Figure 6.
- 3.12 If applicable, re-assemble the modified D4030-041 Long Basket Assembly by attaching modified D3913-041 Long Basket Base Assy to D3914-041/D3915-041 Long Basket Lid Assembly with the retained hardware.
- 3.13 Re-install basket per ICA-D350-607. Replace any worn hardware as necessary per Chapter 5 of ICA-D350-607.
- 3.14 Update the aircraft log book to indicate installation of the DSI 9776-013 End Cover Kit. Update the aircraft Weight and Balance per Section 7.0.

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4.0 INSTALLATION OF DSI 9776-015 ROUND COVER KIT (Short Basket Assembly):

Note: This section provides instructions to install 4x D5519-043 Doubler Assy with 4x D5519-9 Cover Plates on the bottom base of the D4017-041 Short Basket Base Assy. It is also acceptable to install a portion of the DSI 9776-015 Kit.

- 4.1 Temporarily position 4x D5519-043 Doubler Assemblies on the base of the expanded metal of the D4017-041 Basket Base Assy. Mark and trim 4.40" from the center of the doubler assemblies. Locally trim (0.13" - 0.25") the expanded metal that overlaps any of the MS21059L3 anchor nuts as shown in Figure 5.
- 4.2 Tig weld (tack weld) expanded metal at every available location with the D5519-043 Doubler Assy.
- 4.3 If incorporating this DSI during basket production, powder coat entire basket base per D4017 drawing. Mask MS21059L3 anchor nut holes prior to powder coat.
- 4.4 If incorporating this DSI post basket production, paint repaired areas per ICA-D350-607.
- 4.5 Install 4x D5519-9 Cover plates onto the bottom of the D4017-041 Short Basket Base Assy using hardware as shown in Figure 4.
- 4.6 If applicable, re-assemble the modified D4032-041 Short Basket Assembly by attaching the modified D4017-041 Short Basket Base Assy to D4018-041/D4019-041 Short Basket Lid Assembly with the retained hardware.
- 4.7 Re-install basket per ICA-D350-607. Replace any worn hardware as necessary per Chapter 5 of ICA-D350-607.
- 4.8 Update the aircraft log book to indicate installation of the DSI 9776-015 Round Cover Kit. Update the aircraft Weight and Balance per Section 7.0

5.0 INSTALLATION OF DSI 9776-015 ROUND COVER KIT (Long Basket Assembly):

Note: This section provides instructions to install 4x D5519-043 Doubler Assy with 4x D5519-9 Cover Plates on the bottom base of the D3913-041 Long Basket Base Assy. It is also acceptable to install a portion of the DSI 9776-015 Kit.

- 5.1 Temporarily position 4x D5519-043 Doubler Assemblies on the base of the expanded metal of D3913-041 Long Basket Base Assy. Mark and trim 4.40" from the center of the D5519-043 Doubler Assemblies. Locally trim (0.13" - 0.25") the expanded metal that overlaps any of the MS21059L3 anchor nuts as shown in Figure 10.
- 5.2 Tig weld (tack weld) expanded metal at every available location with the D5519-043 Doubler Assy.
- 5.3 If incorporating this DSI during basket production, powder coat entire basket base per D3913 drawing. Mask MS21059L3 anchor nut holes prior to powder coat.
- 5.4 If incorporating this DSI post basket production, paint repaired areas per ICA-D350-607.
- 5.5 Install 4x D5519-3 Cover plates onto the bottom of the D3913-041 Long Basket Base Assy using hardware as shown in Figure 9.
- 5.6 If applicable, re-assemble the modified D4030-041 Long Basket Assembly by attaching the modified D3913-041 Long Basket Base Assy to D3914-041/D3915-041 Long Basket Lid Assembly with the retained hardware.
- 5.7 Re-install basket per ICA-D350-607. Replace any worn hardware as necessary per Chapter 5 of ICA-D350-607.
- 5.8 Update the aircraft log book to indicate installation of the DSI 9776-015 Round Cover Kit. Update the aircraft Weight and Balance per Section 7.0

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6.0 PARTS LIST

QTY -011	QTY -013	QTY -015	PART NUMBER	DESCRIPTION
X			DSI 9776-011	END COVER KIT (SHORT BASKET)
	X		DSI 9776-013	END COVER KIT (LONG BASKET)
		X	DSI 9776-015	ROUND COVER KIT (SHORT/LONG BASKET)
	4		D4021-9	BUSHING
4			D5338-1	BUSHING
2	2		D5519-041	DOUBLER ASSEMBLY
		4	D5519-043	DOUBLER ASSEMBLY
2	2		D5519-3	COVER PLATE
		4	D5519-9	COVER PLATE
16	16	16	AN3-3A	BOLT
4	4		AN3-12A	BOLT
8	8		CCR274CS-3-02	RIVET, BLIND
20	20	16	NAS1149F0332P	WASHER

7.0 WEIGHT AND BALANCE:

The weight of these kits is added to the basket weight. It is the responsibility of the installer to ensure the limitations of FMS-D350-607 and FMS-D355-607 are not exceeded and to update the weight and balance information included in D350-607-3 and ICA-D350-607.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
DSI 9776-011 End Cover Kit (Short Basket)	5.4 lb 2.4 kg	+/- 49.1 in +/- 1.25 m	+/- 265 in-lb +/- 3.0 m-kG	135 in 3.43 m	729 in-lb 8.2 m-kG
DSI 9776-013 End Cover Kit (Long Basket)	5.4 lb 2.4 kg	+/- 49.1 in +/- 1.25 m	+/- 265 in-lb +/- 3.0 m-kG	135 in 3.43 m	729 in-lb 8.2 m-kG
DSI 9776-015 Round Cover Kit (Short/Long Basket)	1.5 lb 0.7 kg	+/- 52.0 in +/- 1.32 m	+/- 78 in-lb +/- 0.9 m-kG	135 in 3.43 m	202 in-lb 2.4 m-kG

8.0 OPERATIONAL REQUIREMENTS:

- All equipment installed in the basket must be mechanically fastened to the basket if the D5519-3/-9 Covers Plate are removed.
- Only covers required for specific mission equipment should be removed.
- Equipment must not extend further than 6" (152 mm) beyond the outer edge of the basket.
- If basket is used for regular missions (ie hauling loose cargo), all covers must be installed.

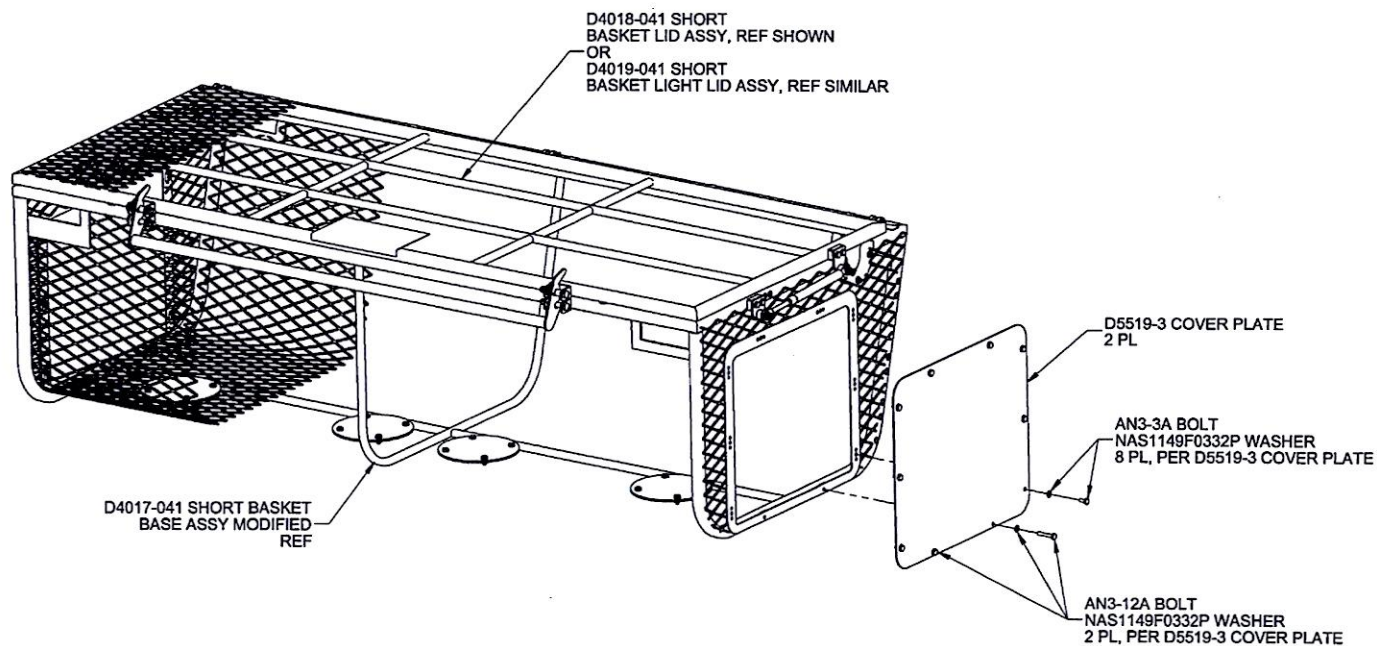
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**FIGURE 1 - DSI 9776-011 END COVER KIT INSTALLATION
ON D4032-041 SHORT BASKET ASSY
(EXPANDED METAL SHOWN PARTIALLY FOR CLARITY)**

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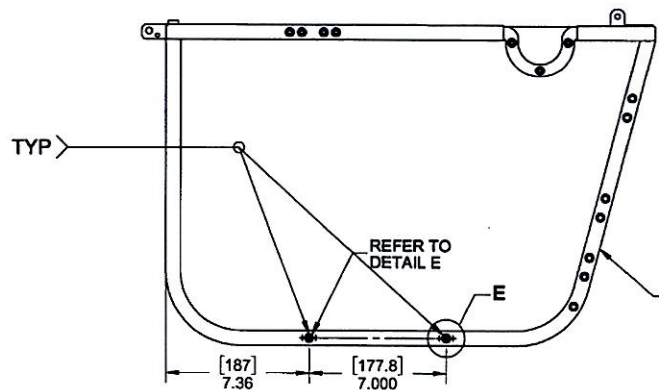
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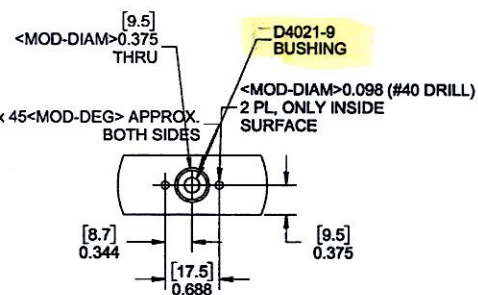
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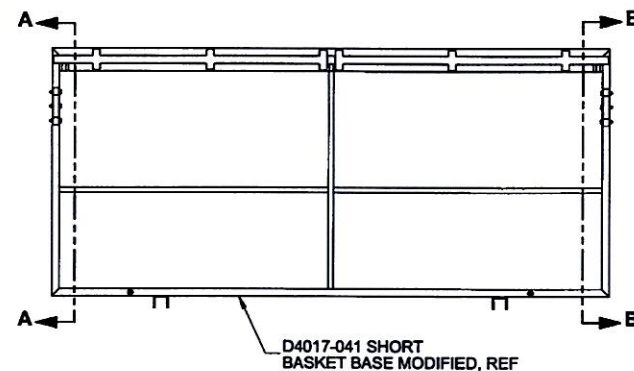
**SECTION A-A SHOWN
(SECTION B-B OPPOSITE)**

D3916-041
RIB ASSY
REF

CSK <MOD-DEG> 0.435 x 45<MOD-DEG> APPROX
BOTH SIDES



**DETAIL E
2 PL**



D4017-041 SHORT
BASKET BASE MODIFIED, REF

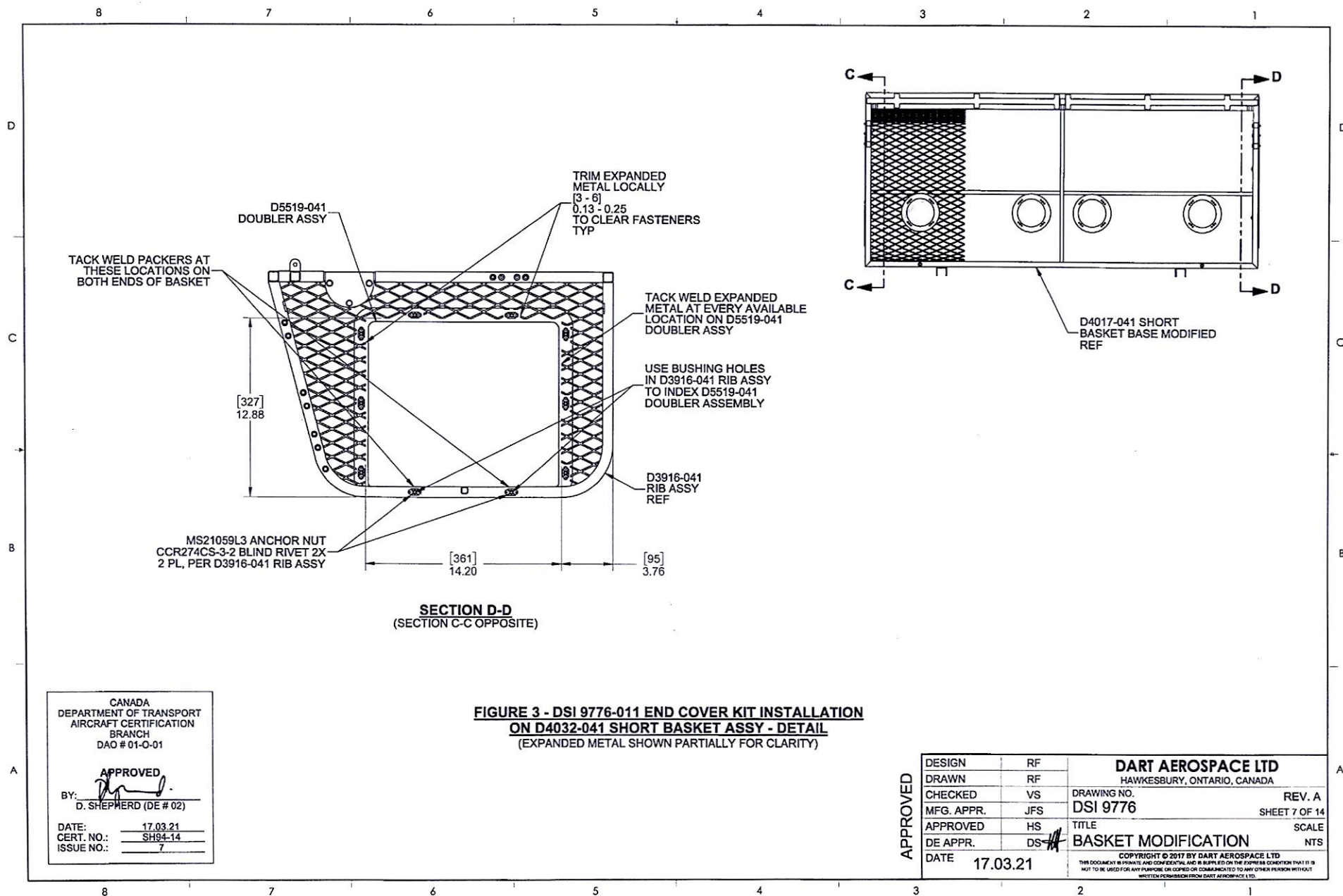
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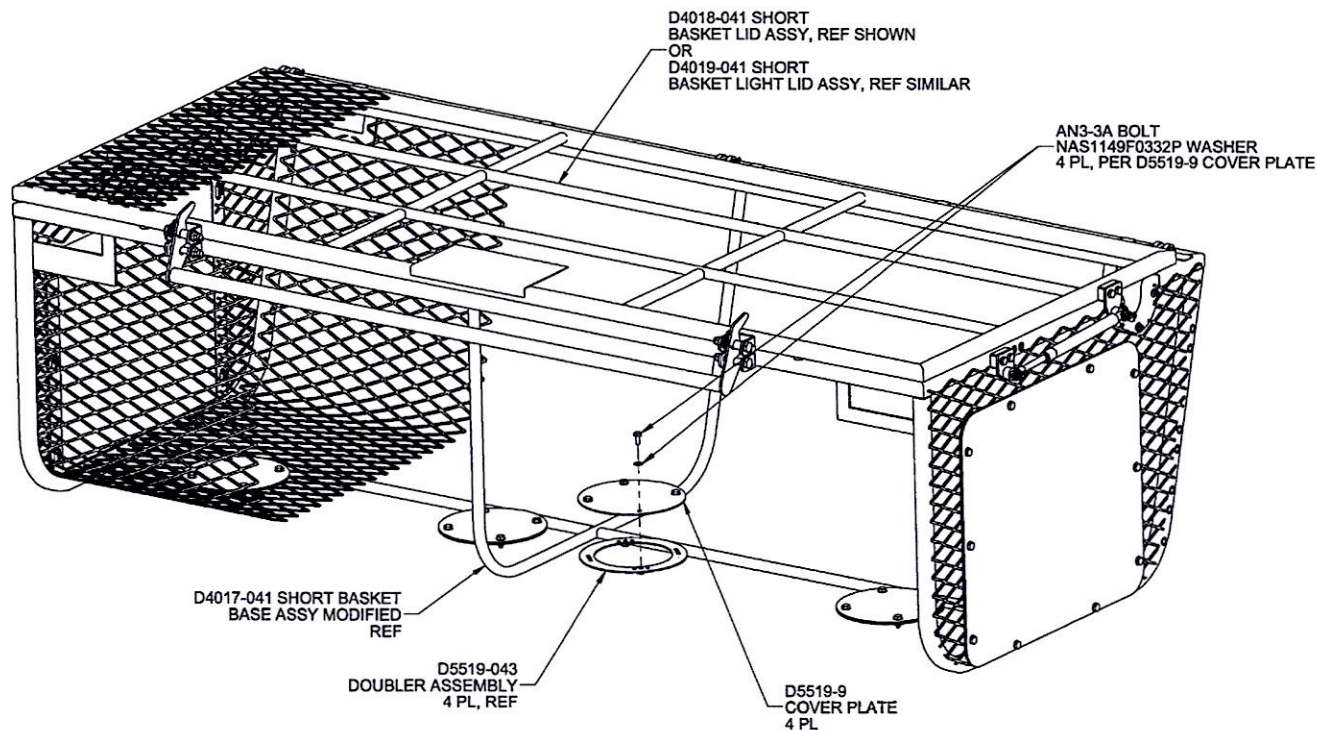
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**FIGURE 2 - DSI 9776-011 END COVER KIT INSTALLATION
ON D4032-041 SHORT BASKET ASSY - DETAIL
(EXPANDED METAL SHOWN PARTIALLY FOR CLARITY)**

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**FIGURE 4 - DSI 9776-015 ROUND COVER KIT INSTALLATION
ON D4032-041 SHORT BASKET ASSY**
(EXPANDED METAL SHOWN PARTIALLY FOR CLARITY)

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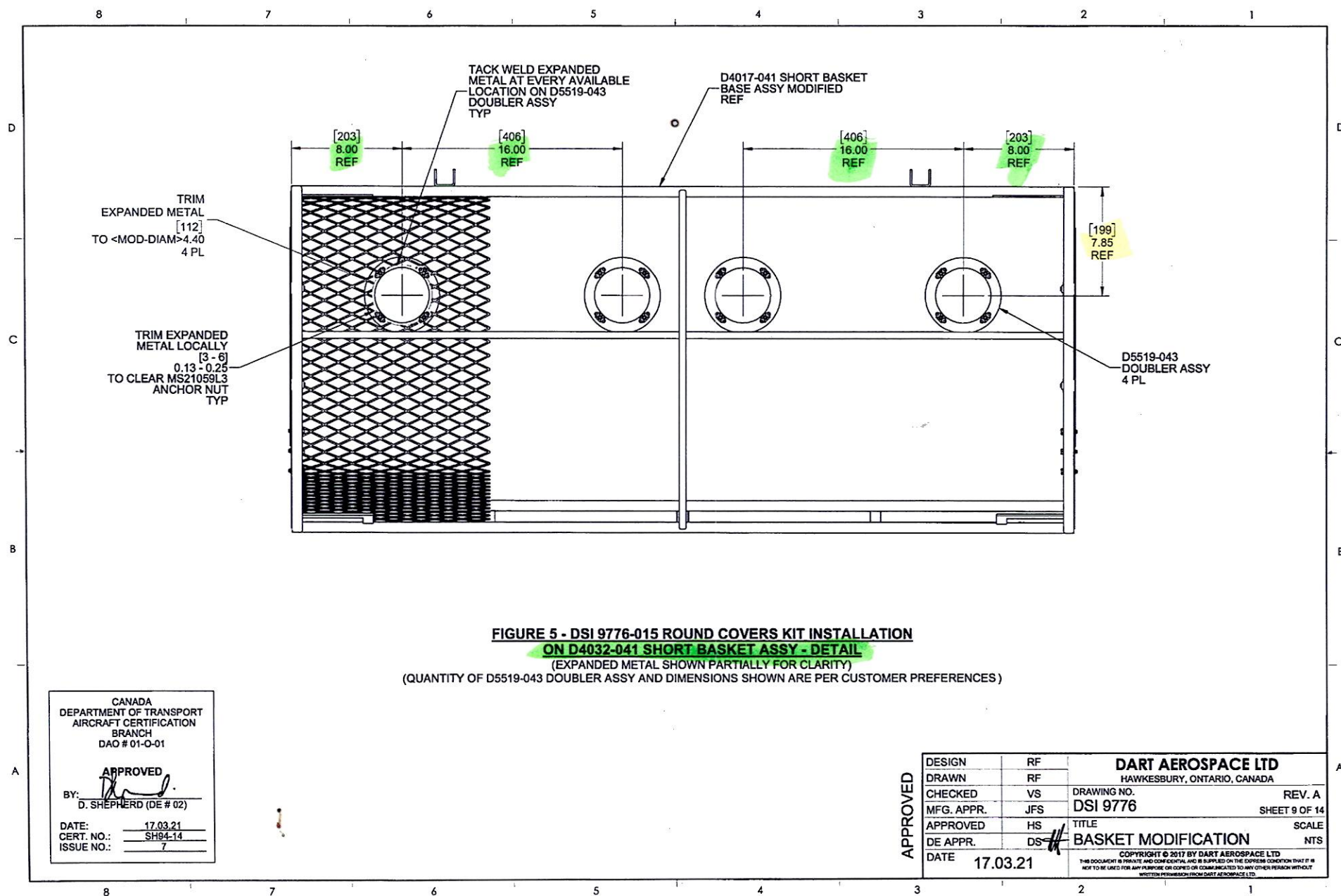
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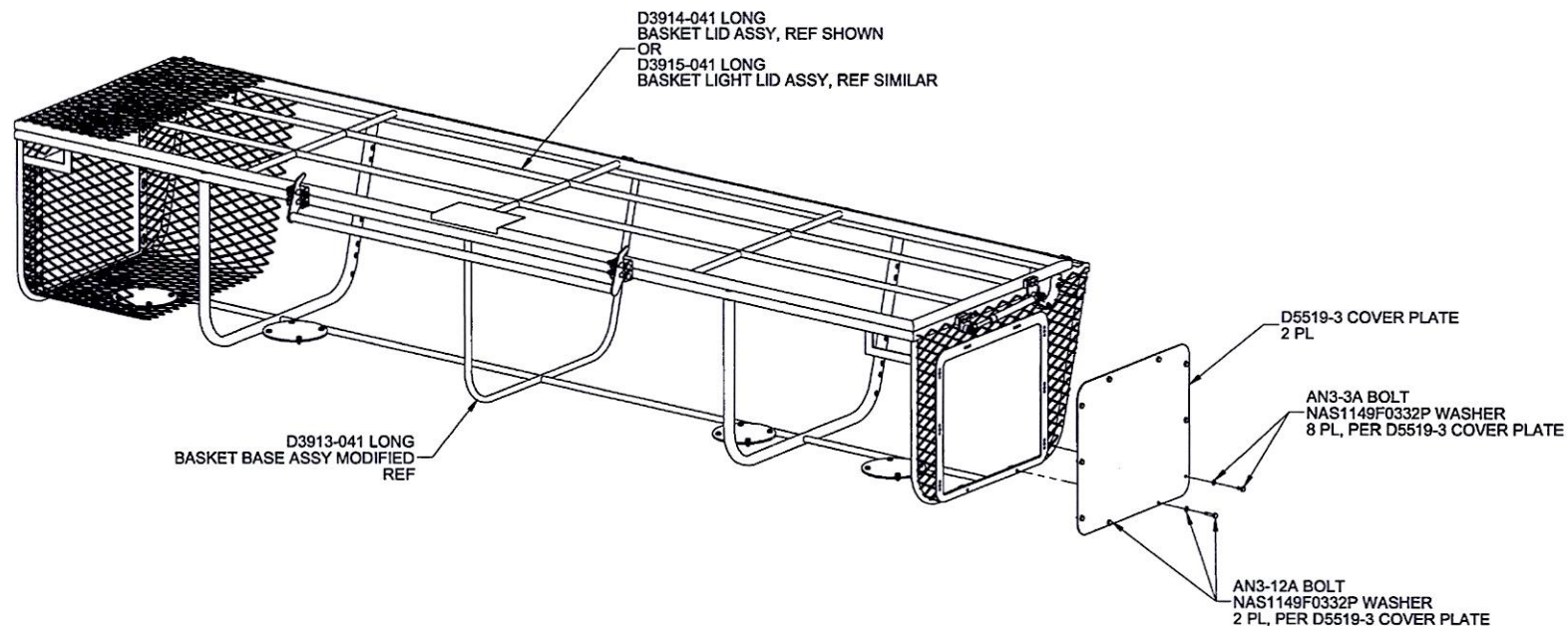
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D. SHEPHERD (DE # 02)

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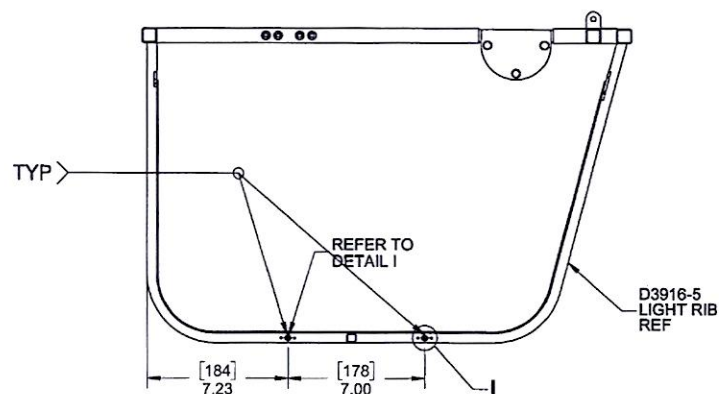


**FIGURE 6 - DSI 9776-013 END COVER KIT INSTALLATION
ON D4030-041 LONG BASKET ASSY
(EXPANDED METAL SHOWN PARTIALLY FOR CLARITY)**

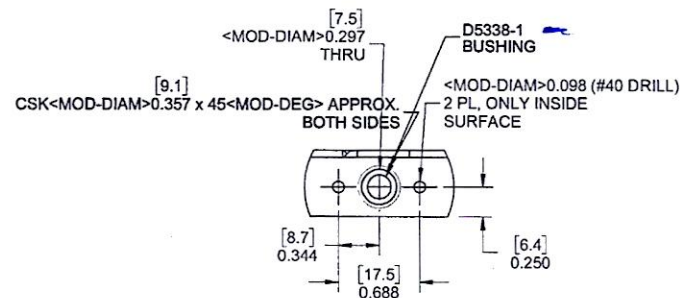
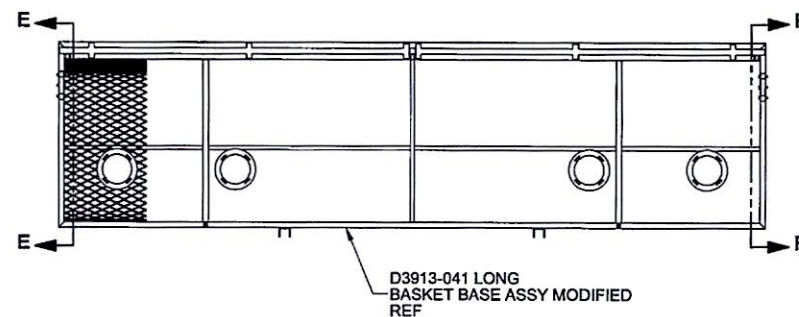
CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)
DATE: 17.03.21
CERT. NO.: SH94-14
ISSUE NO.: 7

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SECTION E-E
(SECTION F-F OPPOSITE)

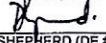


DETAIL I
2 PL

FIGURE 7 - DSI 9776-013 END COVER KIT INSTALLATION
ON D4030-041 LONG BASKET ASSY - DETAIL
(EXPANDED METAL SHOWN PARTIALLY FOR CLARITY)

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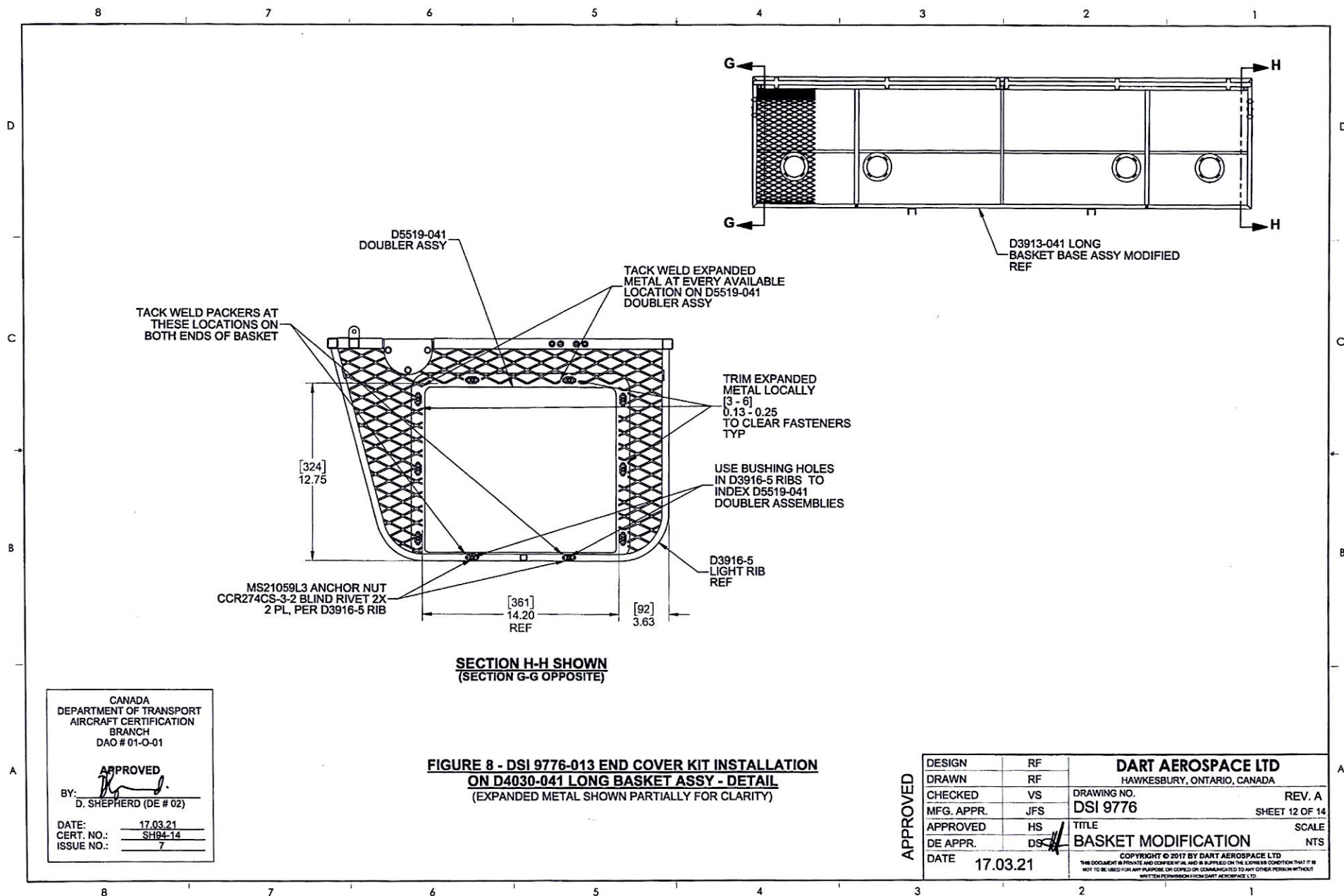
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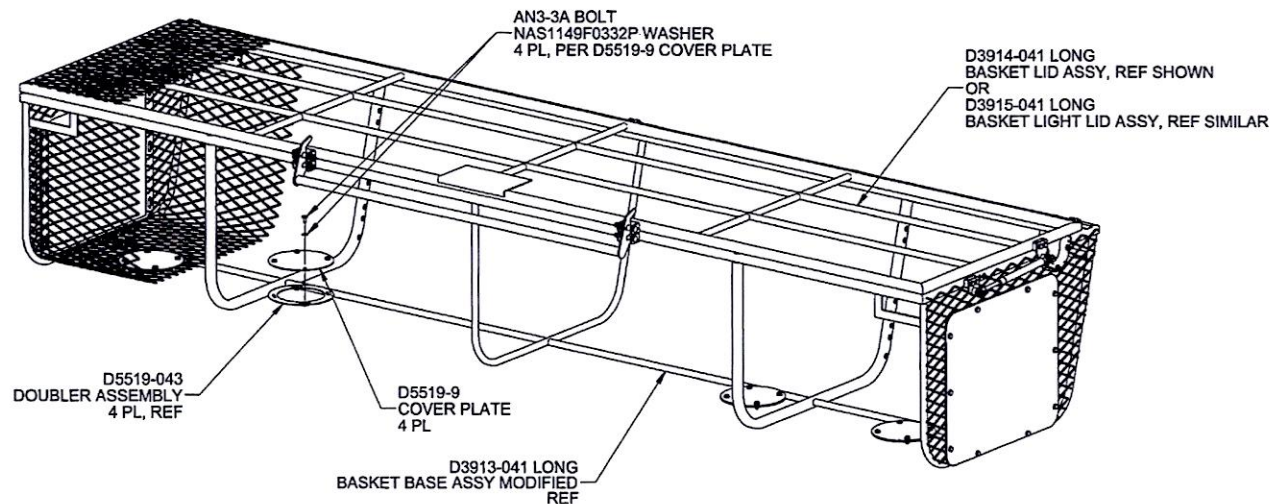
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**FIGURE 9 - DSI 9776-015 ROUND COVER KIT INSTALLATION
ON D4030-041 LONG BASKET ASSY**
(EXPANDED METAL SHOWN PARTIALLY FOR CLARITY)

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